

Date: Monday, 3/26/2007 12:18:18 PM  
 User: Eric Charbonneau

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE ASSY
Job Number : 31477	
Estimate Number : 12706	
P.O. Number : N/A	Part Number : D35725
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3572 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 30671	Material : N/A
Written By : <u>EC</u>	Due Date : 4/2/2007 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est Rev :A New Issue 07-01-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0315 sf(s)/Unit Total : 0.0315 sf(s)

6061-T6 .080 Sheet

Batch: ml 07 03 27

ml 07 03 27

(2)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3572

Dwg Rev: U/R

Prog Rev: U/R

ml 07 03 27

(2)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



ml 07 03 27

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EC 07.03.28

(2)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

form bend as per Dwg D3572

SB 07/03/28

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSY

Job Number: 31477

Part Number: D35725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

✓ 07.03.28

07.03.28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

07.03.28

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

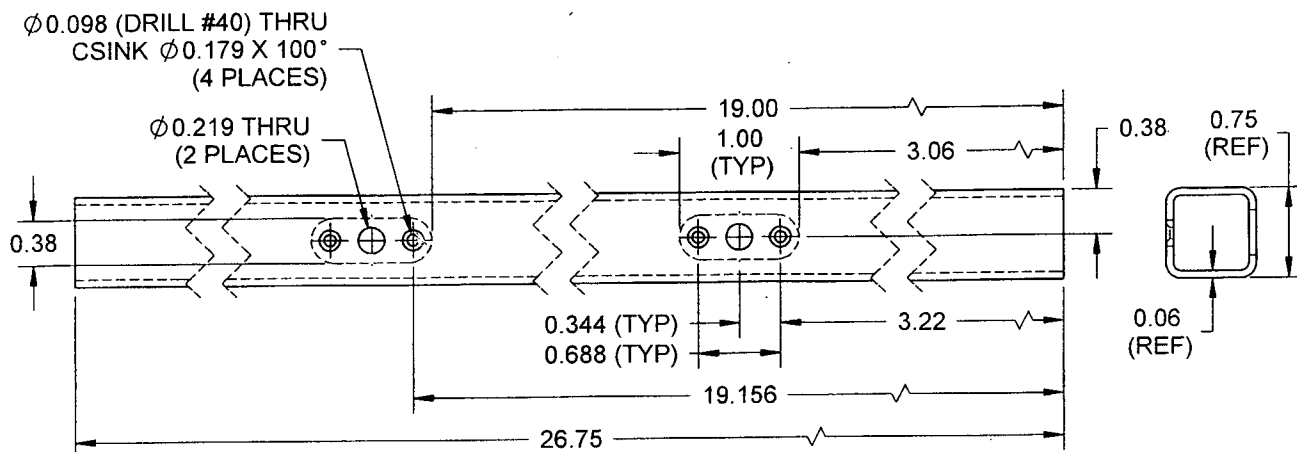
Job Completion



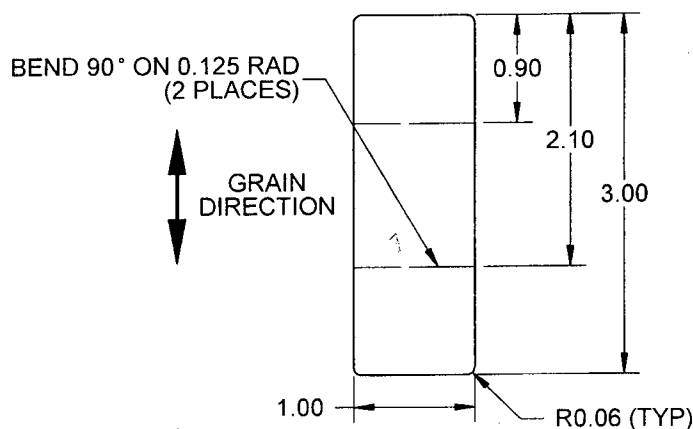
✓ 07.03.29  
00064

**PRELIMINARY ISSUE**  
**UNDER REVIEW**  
 07.03.21 LE

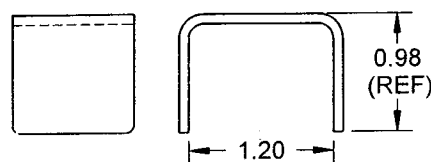
DESIGN LE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.15	TITLE GUIDE ASSEMBLY		SCALE 2:3



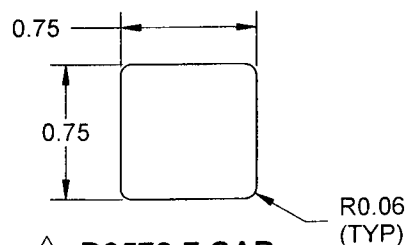
**1 D3572-1 TUBE**



**2 D3572-5F FLAT PATTERN**



**D3572-5 BRACKET**  
 (MAKE FROM D3572-5F)



**2 D3572-7 CAP**

**D3572-1/-5/-7 NOTES:**

- 1) MATERIAL: **1** D3572-1: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM SQUARE TUBE 0.750 X 0.062 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160 (REF DART SPEC M6061T6TS0.750W.062)  
**2** D3572-5/-7: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31477
Description: Guide Assy		Part Number: D3572-5
Inspection Dwg: D3572 Rev: LYR		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.00	$\pm 0.030$	3.00	✓		VERN	
B 1.00	$\pm 0.030$	1.004	✓		VERN	
C R0.06	$\pm 0.030$	R0.06	✓		RADIUS GAUGE	
D						
E 3.000	$\pm 0.030$	2.991	✓		vern.	
F 1.000	$\pm 0.030$	0.991	✓		vern.	
G R.06	$\pm 0.030$	R.06	✓		Rad. gauge.	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: MM. MM	Audited by: E	Prototype Approval: JE N/A
Date: 07 03 27	Date: 07 03 27	Date: 07.03.28 N/A
Rev	Date	Change
		New Issue
		Revised by KJ/RF
		Approved

DOC : V/0080158055

DATUM : 2005-06-14

PROD. REF. : 0000180097/002

NRBST : 63909/01

PAGINA : 1/ 2

P/N: 063567

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES  
WESTERN REGION MATERIALS  
13338 ORDEN DR BLDG H  
SANTA FE SPRINGS, CA 90670 USA

Corus Aluminium N.V.  
A. Stodelaan 67, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO 4522 (COPPER'S PO # W27358)  
ONS ORDERNUMMER : 63909/01  
DOCUMENT NUMBER : V/0080158055

SPECIFICATIES: ALU SHEETS (STENC.) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04  
AFMETINGEN : 144" X 48" X .08"  
ARTIKEL NR. :

ROL-  
NUMMER

GRUT-  
NUMMER

CHEMISCHE ANALYSE (%)

	MIN	SI	FE	CU	MN	MG	CR	TI	ZN
001	0,40	0,7	0,15	0,15	0,8	0,04	0,15	0,25	
	0,8	0,4	0,40	0,09	1,2	0,35	0,02	0,01	
	0,67	0,4	0,20	0,09	1,0	0,15	0,02	0,01	

ANDERE : ELK : MIN 0,05 MAX  
TOTAAL : MIN 0,15 MAX

## MECHANISCHE EIGENSCHAPPEN

TEST-  
NUMMER

1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI  
/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM

	MIN	RM	RP02	A
	MAX	KSI	KSI	%
001	48	41	14	
001	48	41	15	
001	48	41	15	